



Dart Aerospace Ltd.
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D5149-7TRN
Job Sheet 197784



Part No: D5149-7TRN

Job Qty: 8 pcs

Part Name: Aft Step Base Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/26/19

Created By: Manon Dubois

Type: SOLD

Description:

Note: DWG REV D SHEET 10 IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	8 pcs	8/26/19	8/26/19	1.00	4.00	Doosan - 1		
110	QC 2	8 pcs	8/26/19	8/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



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Container No: S201782



Part: D5149-7TRN

Job No: 197784

Serial No/Batch: S201782

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/30/19

120	QC 8	8 pcs	8/26/19	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	19-08-03
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
130	Packaging 3-1 - Stock - B4B	8 pcs	8/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	DAS
				Packaging 3 - 35 - B4B	21
				Packaging 3 - 36 - B4B	9-89
140 QC 21 - SA	8 pcs	8/26/19	0.00 0.00		AUG 06 2019
				QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
					AUG 06 2019

Part Op 100 - Doosan Lathe - Turn blank as per Folio FB356
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location: _____ LOCATION: MAT060
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.250	6061-T6 Round Bar 3.250"	3.3280 ft (.416 ea)	100-Doosan - 1	5/17/2019

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R3.250	3	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Aft Step Base	3.232Inches + 0.012 - 0.001	3.244 3.231	3.23	
2	Aft Step Base	2.875Inches + 0.012 - 0.001	2.887 2.874	2.878	
3	Aft Step Base	0.032Inches ± 0.010	0.042 0.022	Radius	
4	Aft Step Base	0.060Inches ± 0.010	0.070 0.050	.061	
5	Aft Step Base	0.060Inches ± 0.030	0.090 0.030	.064	
6	Aft Step Base	0.875Inches ± 0.010	0.885 0.865	.874	
7	Aft Step Base	3.190Inches ± 0.030	3.220 3.160	3.192	
8	Aft Step Base	4.000Inches ± 0.030	4.030 3.970	3.999	

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